



MoBatch reporting and recipe management for the regulated industry

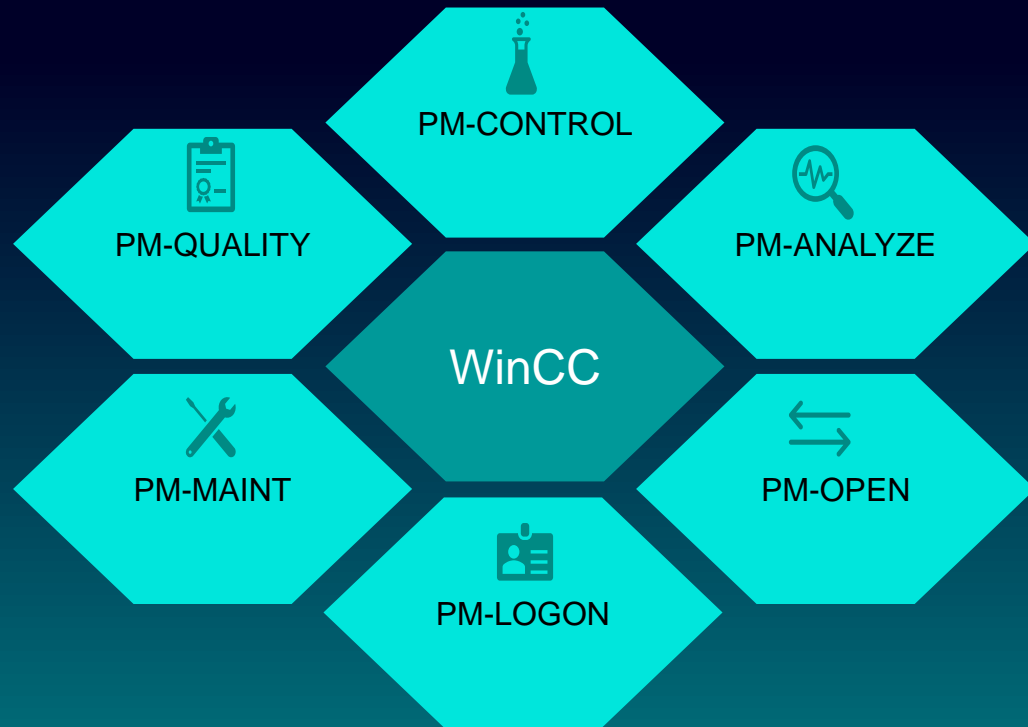
Hans-Jürgen Burath, Siemens AG

SIEMENS

Agenda

- Overview PM-CONTROL
- Live Demo
- Overview PM-QUALITY
- Live Demo
- Wrap up and Q&A

Overview PM-CONTROL



- Management of recipe data, parameter sets, production settings
- Parameter control / Sequence control
- Target independent recipes
- Planning and execution of production orders
- Scalable server editions
- Embeddable clients for different HMI's
- Recipe versioning, Change tracking, Audit Trail, Electronic signatures
- Available languages:
English, French, German, Chinese

System selection and components



PM-CONTROL Server

WinCC Unified PC



PM-CONTROL Server

WinCC V7 / Prof. PC




PM-CONTROL Server

Standalone Server PC

PM-CONTROL Server


Central recipe management

System selection and components




PM-CONTROL Server

WinCC Unified PC



PM-CONTROL Server

WinCC V7 / Prof. PC



PM-CONTROL Server

Standalone Server PC

PM-CONTROL Clients

Clients available for multiple SIMATIC HMI's

PM-CONTROL Client




WinCC Unified PC

PM-CONTROL Client



Unified Comfort Panel

PM-CONTROL Client



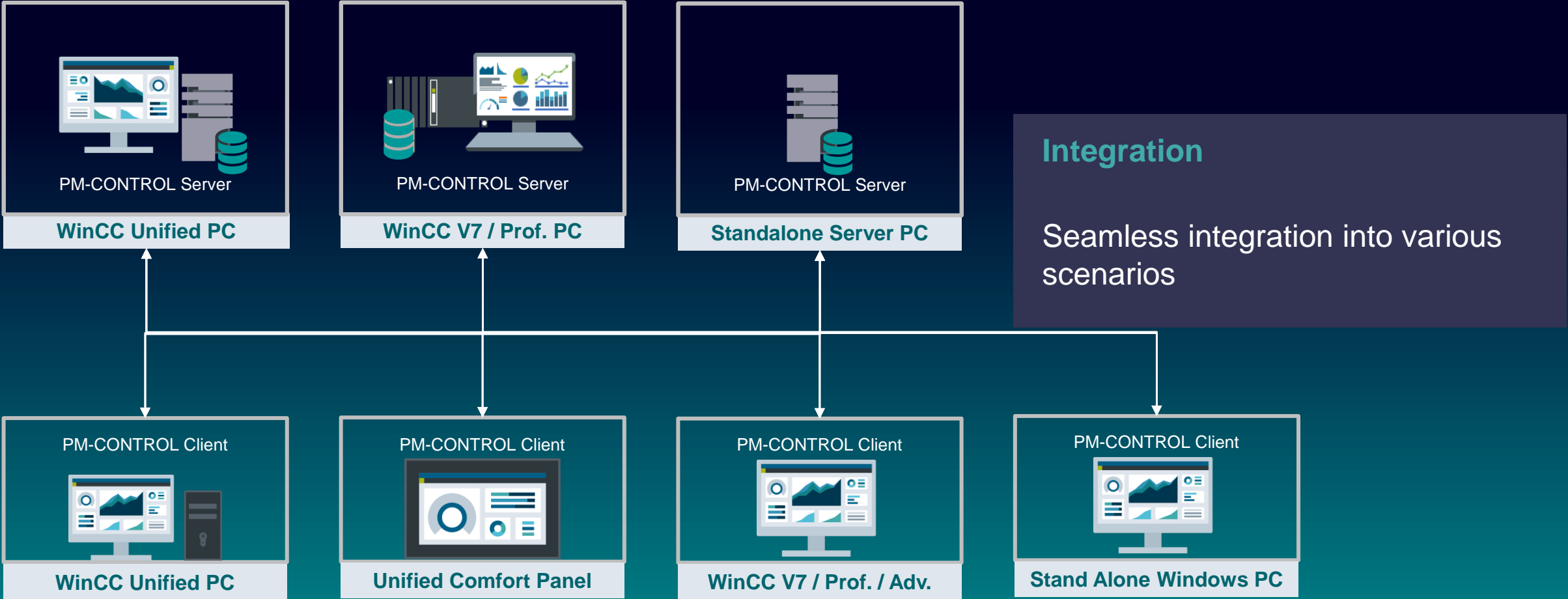
WinCC V7 / Prof. / Adv.

PM-CONTROL Client



Stand Alone Windows PC

System selection and components



System selection and components

PM-CONTROL recipe system

- Display and selection of recipes

Name	Short Name
Formulation1	FO1
Formulation2	FO2
Formulation3	FO3
Packaging1	PA1

Body Lotion

Experimental

Peppermint Fresh

For Men

For Women

Cinnamon Touch

Lavender Dream

Rosewater Romance

Strawberry Love

Neutral

Test

1

2

1 - 5 of 8 steps

Name	Value	Dose Water	Dose Oil	Dose Emulgator	Heat Up	Dose Perfum
Parameters						
DelayTime	0 s	0 s	0 s	0 s		
Delay	Off	Off	Off	Off		
Draining	Off	Off	Off	Off		
EmulsifierQuantity	0.0 Kg	0.0 Kg	6.5 Kg	0.0 Kg	0.0 l	
EmulsifierDosing	Off	Off	On	Off		
HeatingTemp	0 °C	0 °C	0 °C	82 °C	67 °C	
Heating	On	Off	Off	On		
OilQuantity	20.0 l	13.0 l	0.0 l	0.0 l	0.0 l	
OilDosing	Off	On	Off	Off		
PerfumeQuantity	0.00 l	0.00 l	0.00 l	0.00 l	2.2 l	
PerfumeDosing	Off	Off	Off	Off		
StiringRPM	0 rpm	0 rpm	0 rpm	377 rpm	250 rpm	
StiringOn	Off	Off	Off	On		
WaterQuantity	86 l	0 l	0 l	0 l		
WaterDosing	On	Off	Off	Off		

System selection and components

PM-CONTROL recipe system

- Display and selection of recipes
 - For operators and process experts

The screenshot displays the Siemens PM-CONTROL recipe system interface. On the left, a tree view shows the hierarchy: Body Lotion > For Women > Lavender Dream (selected). The main area is divided into tabs: General, Production Units, Steps, Parameters, and Audit Trail. The 'General' tab is active, showing the following data:

General Data	
Name:	Lavender Dream
Number:	LVD
Short Name:	
Product Name:	
Version:	V47

Below the General Data section is the 'Scaling' section:

Scaling:	
Scale Type:	Scaled
Reference Value:	100

At the bottom is the 'History' section:

History	
Creation date:	10/3/2019 4:17 PM
Created by:	siemens
Change date:	8/2/2022 9:32 AM
Changed by:	siemens

System selection and components

PM-CONTROL recipe system

- Display and selection of recipes
 - For operators and process experts
- Display and editing of assigned production units

The screenshot displays the PM-CONTROL recipe system interface. On the left, a tree view shows the hierarchy: Body Lotion > For Women > Lavender Dream (selected). The main area shows the 'Parameters' tab for step 1 of 8. The table lists various parameters and their values, with 'PerfumeQuantity' highlighted.

Name	Value					Topology Limits		Recipe Limits		Material
	Dose Water	Dose Oil	Dose Emulgator	Heat Up	Dose Perfume	Lower Limit	Upper Limit	Lower Limit	Upper Limit	
▼ Parameters										
▼ DelayTime	0 s	0 s	0 s	0 s	0 s					
Delay	Off	Off	Off	Off	Off					
Draining	Off	Off	Off	Off	Off					
▼ EmulsifierQuantity	0.0 Kg	0.0 Kg	6.5 Kg	0.0 Kg	0.0 Kg					
EmulsifierDosing	Off	Off	On	Off	Off					
▼ HeatingTemp	0 °C	0 °C	0 °C	82 °C	67 °C	0 °C	200 °C			
Heating	On	Off	Off	On	On					
▼ OilQuantity	20.0 l	13.0 l	0.0 l	0.0 l	0.0 l					
OilDosing	Off	On	Off	Off	Off					
▼ PerfumeQuantity	0.00 l	0.00 l	11.00 l	0.00 l	2.20 l					Lavender
PerfumeDosing	Off	Off	Off	Off	On					
▼ StiringRPM	0 rpm	0 rpm	0 rpm	377 rpm	250 rpm					
StiringOn	Off	Off	Off	On	On					
▼ WaterQuantity	86 l	0 l	0 l	0 l	0 l					
WaterDosing	On	Off	Off	Off	Off					

System selection and components

PM-CONTROL recipe system

- Display and selection of recipes
 - For operators and process experts
- Display and editing of assigned production units
- Editing of recipe steps

The screenshot displays the Siemens PM-CONTROL recipe system interface. On the left, a tree view shows the hierarchy: Body Lotion > Experimental > For Men > For Women > Lavender Dream (selected). The main area shows the 'Parameters' tab for the selected recipe. The interface includes a step indicator (1 - 5 of 8 steps) and a table of parameters.

Name	Value					Topology Limits		Recipe Limits		Material
	Dose Water	Dose Oil	Dose Emulgator	Heat Up	Dose Perfume	Lower Limit	Upper Limit	Lower Limit	Upper Limit	
▼ Parameters										
▼ DelayTime	0 s	0 s	0 s	0 s	0 s					
Delay	Off	Off	Off	Off	Off					
Draining	Off	Off	Off	Off	Off					
▼ EmulsifierQuantity	0.0 Kg	0.0 Kg	6.5 Kg	0.0 Kg	0.0 Kg					
EmulsifierDosing	Off	Off	On	Off	Off					
▼ HeatingTemp	0 °C	0 °C	0 °C	82 °C	67 °C	0 °C	200 °C			
Heating	On	Off	Off	On	On					
▼ OilQuantity	20.0 l	13.0 l	0.0 l	0.0 l	0.0 l					
OilDosing	Off	On	Off	Off	Off					
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PerfumeDosing	Off	Off	Off	Off	On					
▼ StirringRPM	0 rpm	0 rpm	0 rpm	377 rpm	250 rpm					
StirringOn	Off	Off	Off	On	On					
▼ WaterQuantity	86 l	0 l	0 l	0 l	0 l					
WaterDosing	On	Off	Off	Off	Off					

System selection and components

PM-CONTROL recipe system

- Display and selection of recipes
 - For operators and process experts
- Display and editing of assigned production units
- Editing of recipe steps
- Parameter quick search for editing

The screenshot displays the PM-CONTROL recipe system interface. On the left, a tree view shows the hierarchy: Body Lotion > Experimental > For Men > For Women > Lavender Dream (selected). The main area shows the 'General' tab for the selected recipe. It includes a table of parameters and their values, along with topology and recipe limits.

Name	Value					Topology Limits		Recipe Limits		Material
	Dose Water	Dose Oil	Dose Emulgator	Heat Up	Dose Perfume	Lower Limit	Upper Limit	Lower Limit	Upper Limit	
▼ DelayTime	0 s	0 s	0 s	0 s	0 s					
Delay	Off	Off	Off	Off	Off					
Draining	Off	Off	Off	Off	Off					
▼ EmulsifierQuantity	0.0 Kg	0.0 Kg	6.5 Kg	0.0 Kg	0.0 Kg					
EmulsifierDosing	Off	Off	On	Off	Off					
▼ HeatingTemp	0 °C	0 °C	0 °C	82 °C	67 °C	0 °C	200 °C			
Heating	On	Off	Off	On	On					
▼ OilQuantity	20.0 l	13.0 l	0.0 l	0.0 l	0.0 l					
OilDosing	Off	On	Off	Off	Off					
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PerfumeDosing	Off	Off	Off	Off	On					
▼ StirringRPM	0 rpm	0 rpm	0 rpm	377 rpm	250 rpm					
StirringOn	Off	Off	Off	On	On					
▼ WaterQuantity	86 l	0 l	0 l	0 l	0 l					
WaterDosing	On	Off	Off	Off	Off					

System selection and components

PM-CONTROL recipe system

- Display and selection of recipes
 - For operators and process experts
- Display and editing of assigned production units
- Editing of recipe steps
- Parameter quick search for editing
- Integrated recipe audit trail

The screenshot displays the PM-CONTROL recipe system interface. On the left, a tree view shows the recipe hierarchy: Body Lotion (Experimental, For Men, For Women, Neutral), Packaging, and Test (Lavender Dream Gentle). The 'Lavender Dream' recipe is selected. The main area shows the 'Parameters' tab with a table of parameters and their values. The table has columns for Name, Value, Dose Water, Dose Oil, Dose Emulgator, Heat Up, Dose Perfume, Topology Limits (Lower Limit, Upper Limit), Recipe Limits (Lower Limit, Upper Limit), and Material. The 'PerfumeQuantity' parameter is highlighted with a red box, showing a value of 11.00 and a material of Lavender.

Name	Value	Dose Water	Dose Oil	Dose Emulgator	Heat Up	Dose Perfume	Topology Limits	Recipe Limits	Material		
							Lower Limit	Upper Limit	Lower Limit	Upper Limit	
▼ DelayTime	0 s	0 s	0 s	0 s	0 s	0 s					
Delay	Off	Off	Off	Off	Off	Off					
Draining	Off	Off	Off	Off	Off	Off					
▼ EmulsifierQuantity	0.0 Kg	0.0 Kg	6.5 Kg	0.0 Kg	0.0 Kg	0.0 Kg					
EmulsifierDosing	Off	Off	On	Off	Off	Off					
▼ HeatingTemp	0 °C	0 °C	0 °C	82 °C	67 °C	0 °C	200 °C				
Heating	On	Off	Off	On	On						
▼ OilQuantity	20.0 l	13.0 l	0.0 l	0.0 l	0.0 l	0.0 l					
OilDosing	Off	On	Off	Off	Off	Off					
▼ PerfumeQuantity	0.00 l	0.00 l	11.00		0.00 l	2.20 l					Lavender
PerfumeDosing	Off	Off	Off	Off	On	On					
▼ StiringRPM	0 rpm	0 rpm	0 rpm	377 rpm	250 rpm						
StiringOn	Off	Off	Off	On	On						
▼ WaterQuantity	86 l	0 l	0 l	0 l	0 l	0 l					
WaterDosing	On	Off	Off	Off	Off	Off					

System selection and components

PM-CONTROL recipe system

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- Extensive styling support for seamless integration into corporate designs

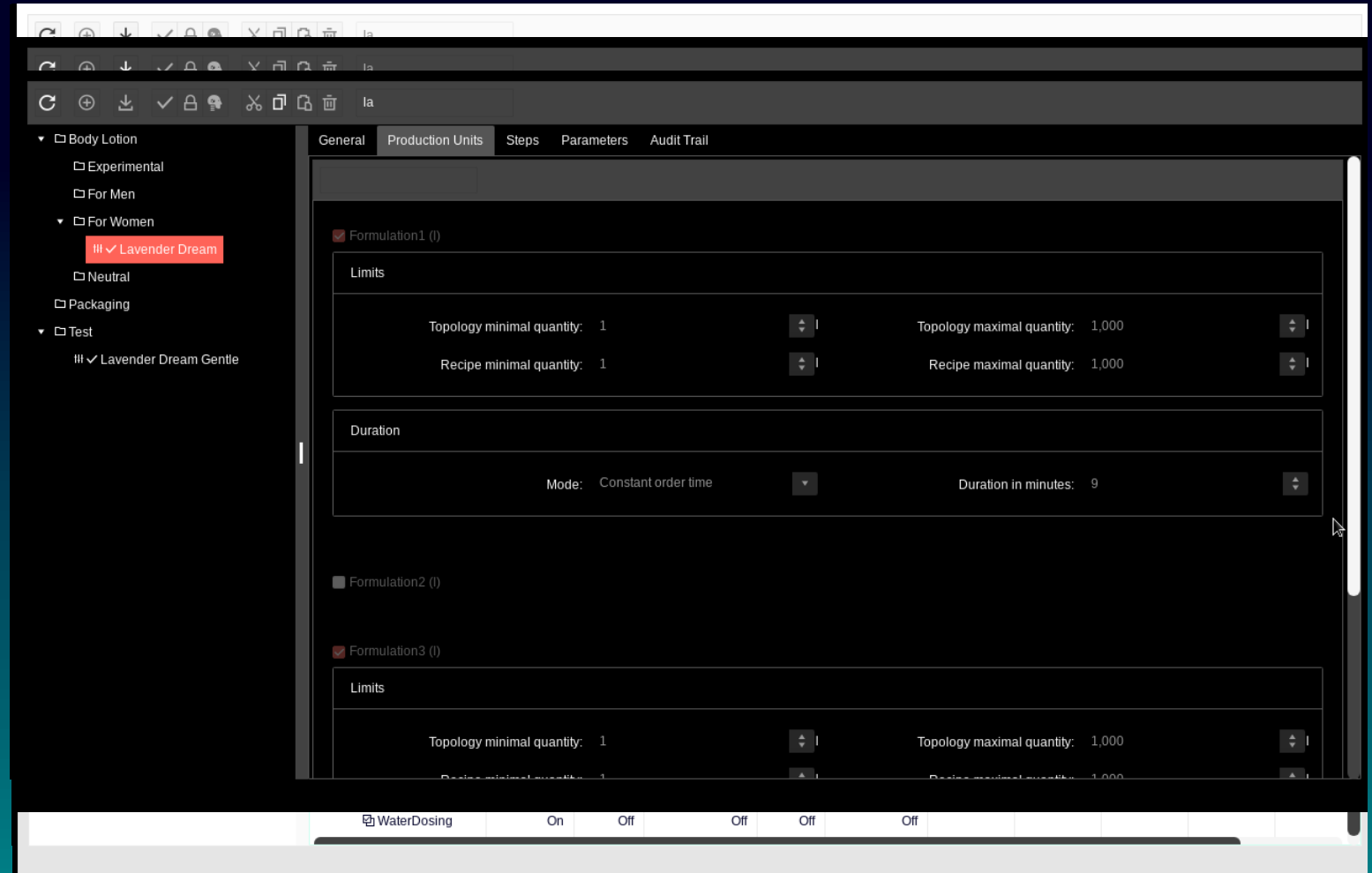
The screenshot displays the Siemens PM-CONTROL recipe system interface. On the left, a tree view shows the recipe hierarchy: Body Lotion > Experimental > For Men > For Women > Lavender Dream (selected) > Neutral > Packaging > Test > Lavender Dream Gentle (selected). The main area shows the 'Parameters' tab for this recipe. The interface includes a navigation bar with tabs: General, Production Units, Steps, Parameters (active), and Audit Trail. Below the tabs, a progress indicator shows '1 - 5 of 8 steps'. The main table lists parameters with columns for Name, Value, Dose Water, Dose Oil, Dose Emulgator, Heat Up, Dose Perfume, Topology Limits (Lower Limit, Upper Limit), Recipe Limits (Lower Limit, Upper Limit), and Material. The 'HeatingTemp' parameter is highlighted, showing a value of 82 °C and a material of Lavender.

Name	Value					Topology Limits		Recipe Limits		Material
	Dose Water	Dose Oil	Dose Emulgator	Heat Up	Dose Perfume	Lower Limit	Upper Limit	Lower Limit	Upper Limit	
▼ Parameters										
▼ DelayTime	0 s	0 s	0 s	0 s	0 s					
Delay	Off	Off	Off	Off	Off					
Draining	Off	Off	Off	Off	Off					
▼ EmulsifierQuantity	0.0 Kg	0.0 Kg	6.5 Kg	0.0 Kg	0.0 Kg					
EmulsifierDosing	Off	Off	On	Off	Off					
▼ HeatingTemp	0 °C	0 °C	0 °C	82 °C	67 °C	0 °C	200 °C			
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PerfumeDosing	Off	Off	Off	Off	On					
▼ StirringRPM	0 rpm	0 rpm	0 rpm	377 rpm	250 rpm					
StirringOn	Off	Off	Off	On	On					
▼ WaterQuantity	86 l	0 l	0 l	0 l	0 l					
WaterDosing	On	Off	Off	Off	Off					

System selection and components

PM-CONTROL recipe system

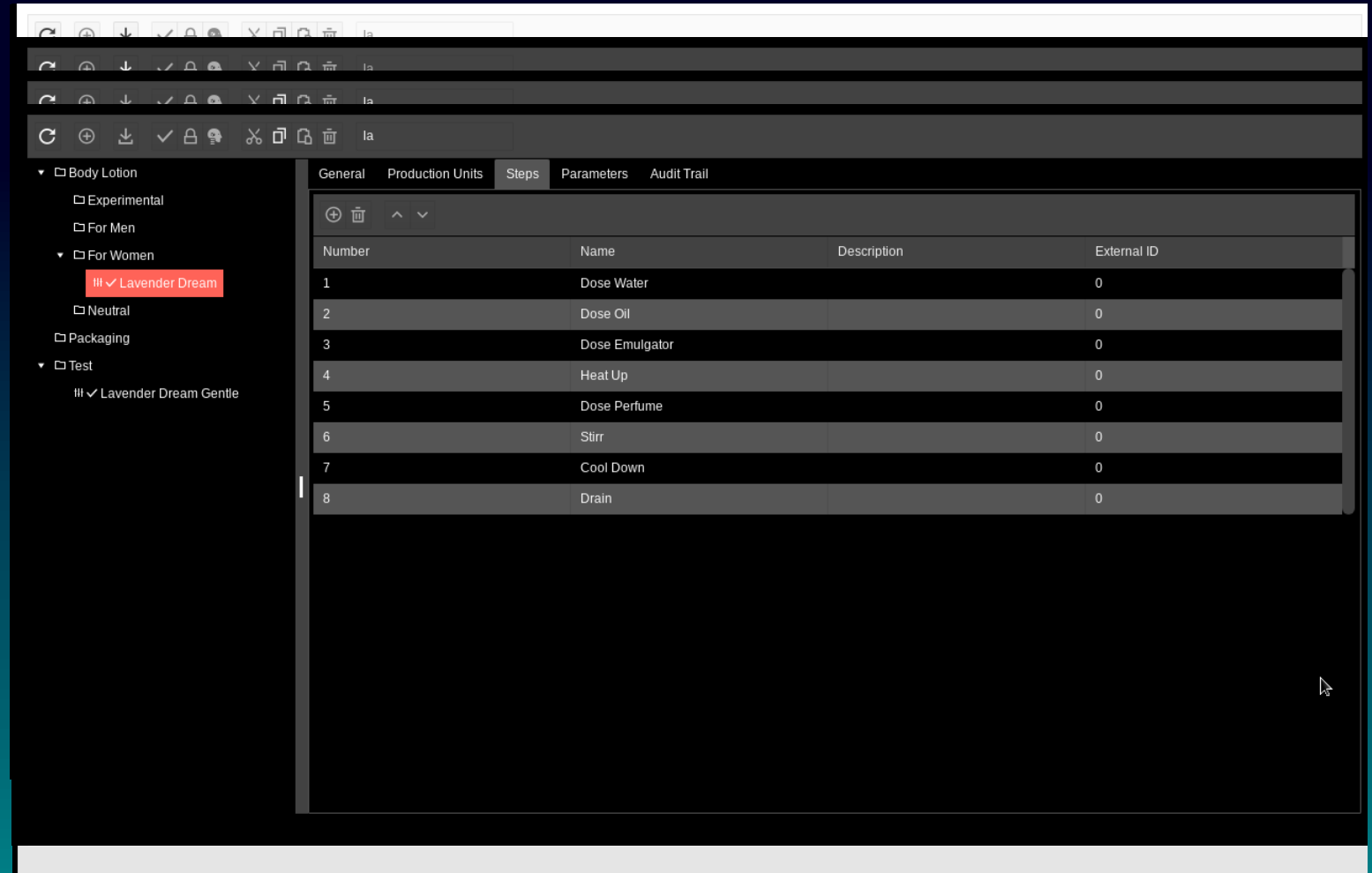
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System selection and components

PM-CONTROL recipe system

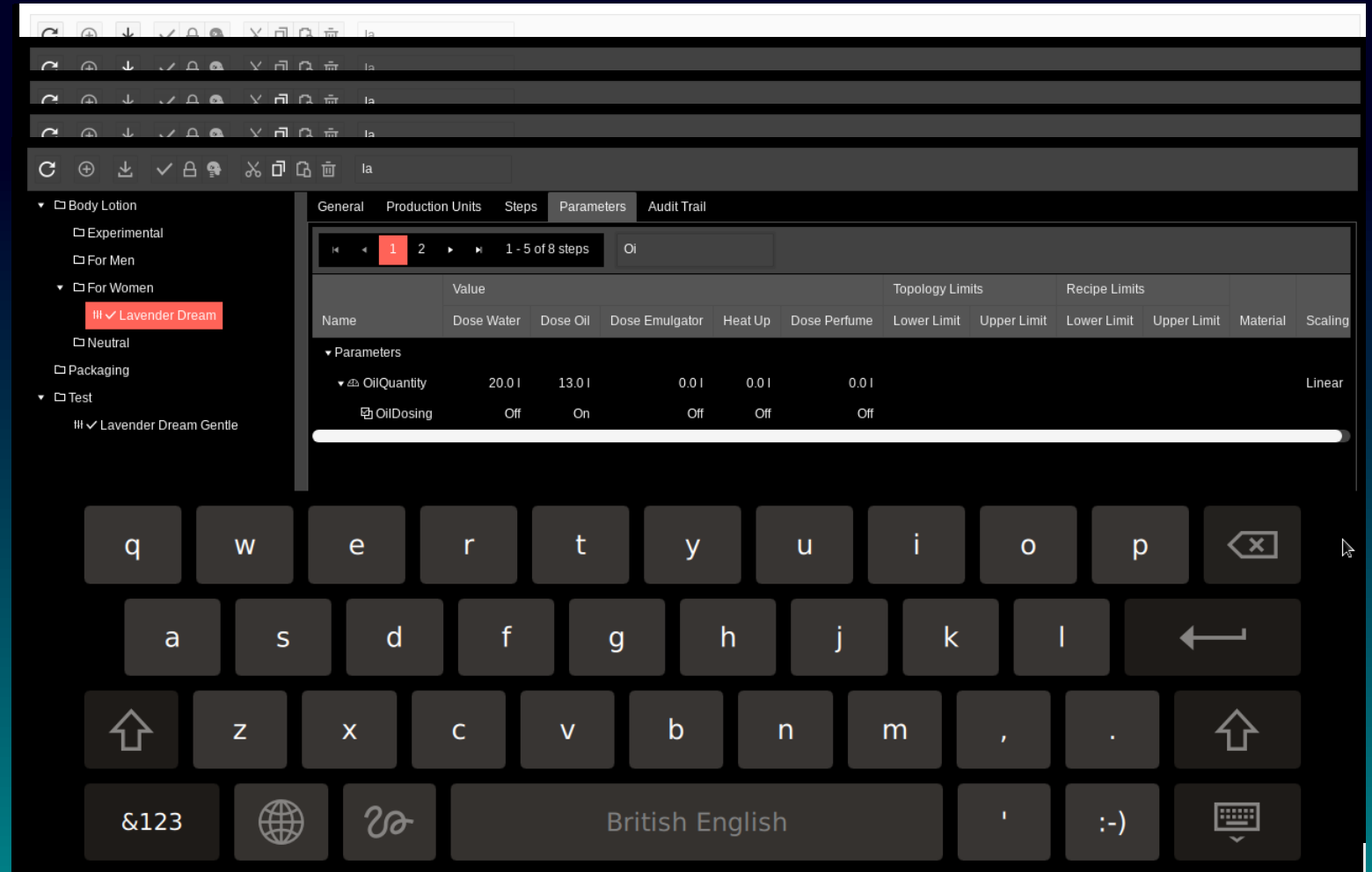
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System selection and components

PM-CONTROL recipe system

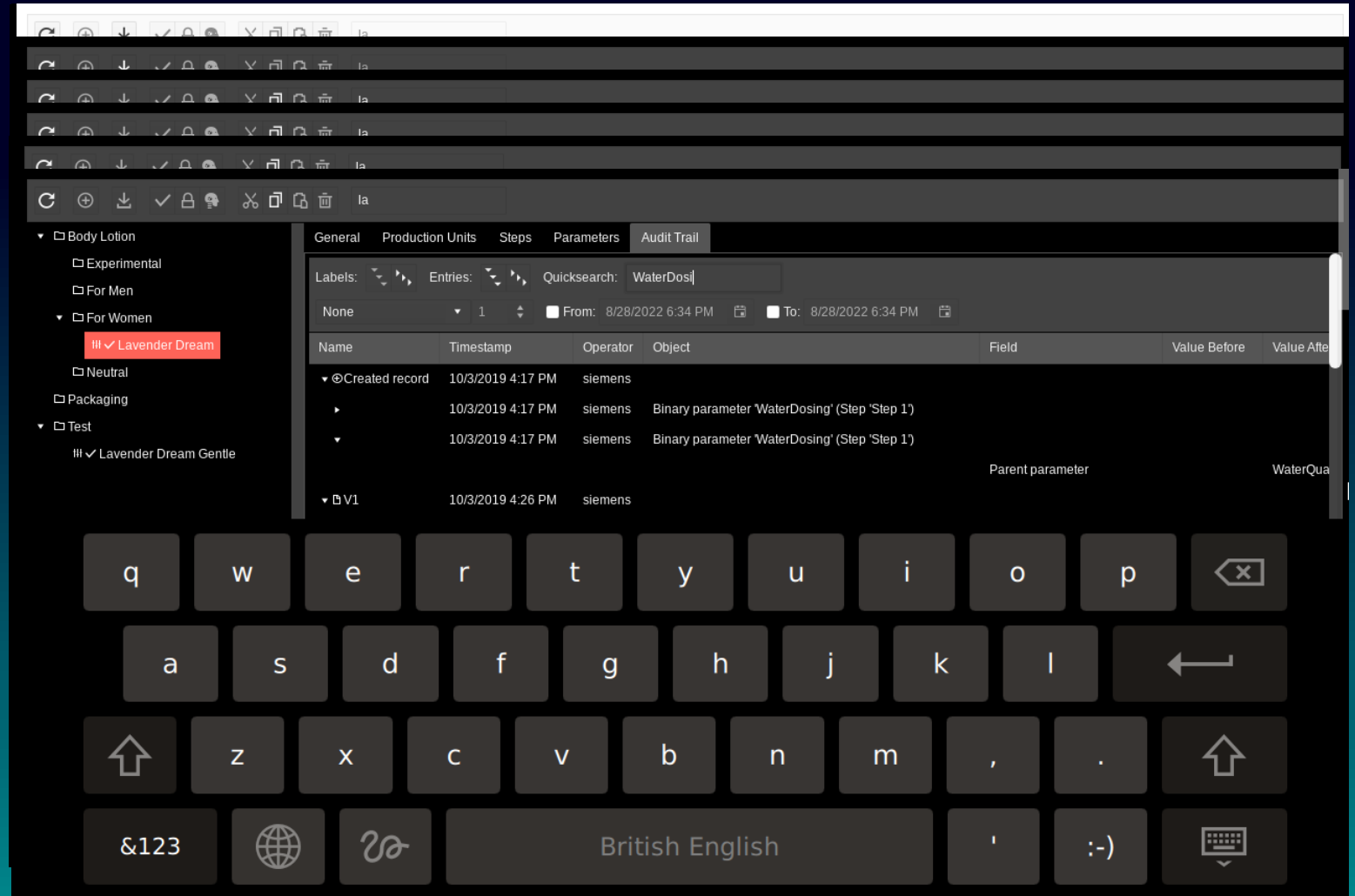
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System selection and components

PM-CONTROL recipe system

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System selection and components

PM-CONTROL order processing

- Display of scheduled production orders

Formulation1Formulation2Formulation3Packaging1

Processed Jobs						
State	Job Name	Batch name	Recipe Name	Recipe Number	Recipe Version	Set Quantity
🏁 Finished	A133	A133-FO1-CMN-202109141521	Cinnamon Touch	CMN	V2	300 l
🏁 Finished	A134	A134-FO1-STB-202109210909	Strawberry Love	STB	V4	500 l
🏁 Finished	A135	A135-FO1-MSK-202110041421	Musk Power	MSK	V3	500 l
🏁 Finished	A136	A136-FO1-CMN-202110081622	Cinnamon Touch	CMN	V2	600 l
🏁 Finished	A139	A139-FO1-CMN-202110271032	Cinnamon Touch	CMN	V3	800 l

Current Job

State	Job Name	Batch name	Recipe Name	Recipe Number	Recipe Version	Set Quantity
No data available						

Planned Jobs

State	Job Name	Batch name	Recipe Name	Recipe Number	Recipe Version	Set Quantity
No data available						

System selection and components

PM-CONTROL order processing

- Display of scheduled production orders
- Integrated order wizard for order creation

The screenshot displays the 'New Job' wizard in the PM-CONTROL system. The wizard is a multi-step process with four stages: General, Recipe Selection (current), Quantity, and Summary. The 'Recipe Selection' step is active, showing a search bar with 'Lav' entered and a list of results. The results are categorized under 'Body Lotion' and 'Test'. Under 'Body Lotion', there is a sub-category 'For Women' with a red checkmark next to 'Lavender Dream'. Under 'Test', there is a sub-category 'Lavender Dream Gentle' with a red checkmark next to it. The bottom of the wizard has four buttons: 'Cancel', 'Previous', 'Next', and 'Finish' (highlighted in red).

New Job

General Recipe Selection Quantity Summary

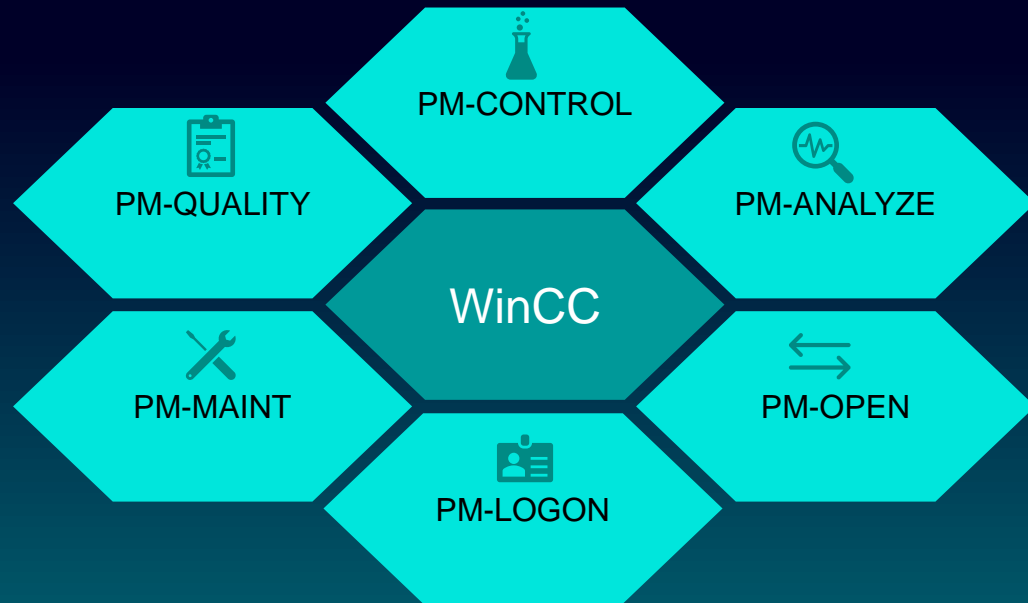
Recipe Selection
Please select a recipe for the job

Search: Lav

- Body Lotion
 - For Women
 - ☒ Lavender Dream
- Test
 - ☒ Lavender Dream Gentle

Cancel Previous Next Finish

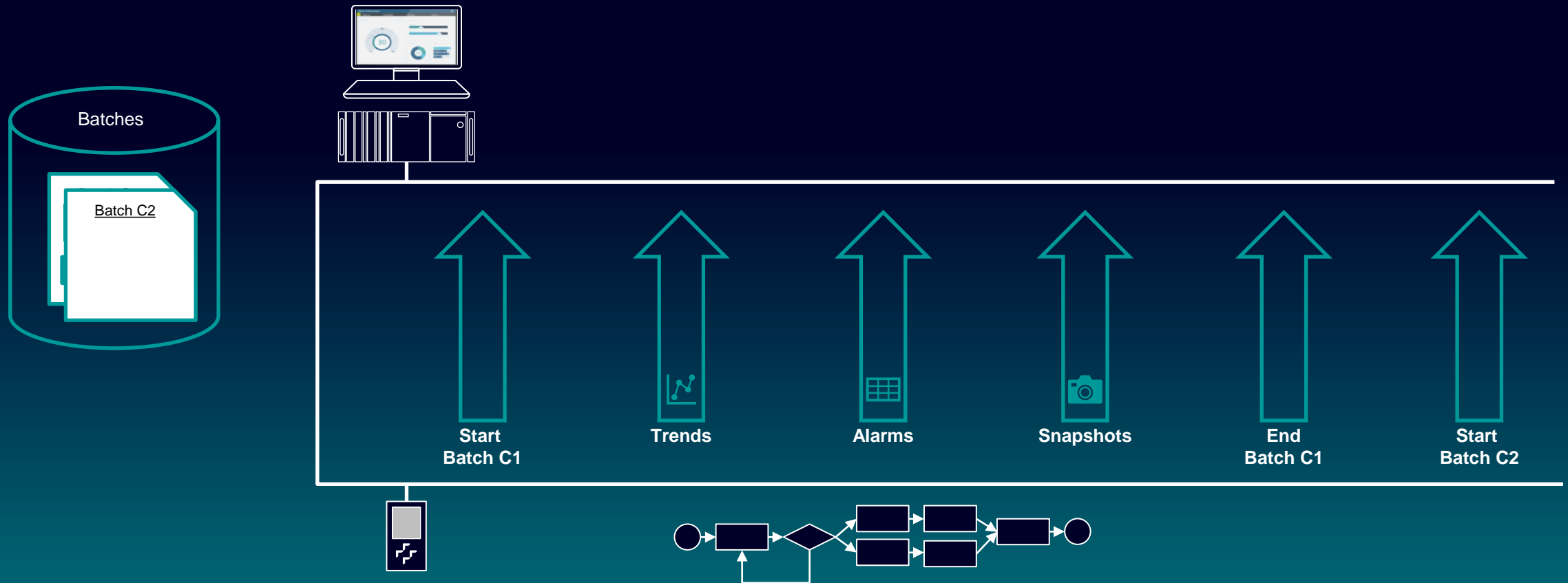
Overview PM-QUALITY



- Batch based data recording of
 - Trends
 - Alarm messages / audit trail messages / Exceptions
 - Event triggered readings (Snapshots)
 - Manual input values
- Display of trends, alarms, snapshots and comments from current and historical trends in one diagram
- Comfortable creation of report-layouts
 - Integrated Report Editor
- Automatic report generation at end of batch
 - Printout , pdf, html, xml file
- Long term archiving

Batch concept in PM-QUALITY

Data recording

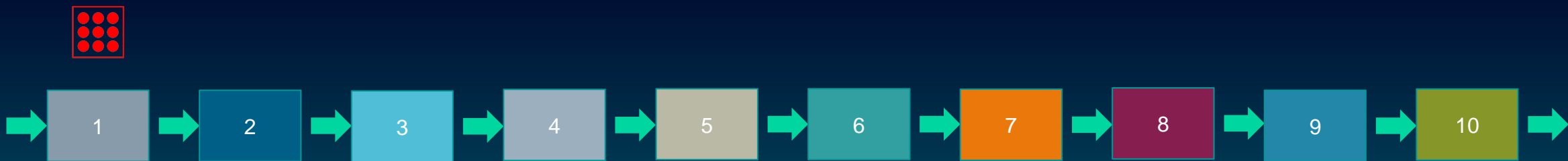


- All captured data is stored under the name of the batch.
- The recording period is defined via a Start / Stop signal.

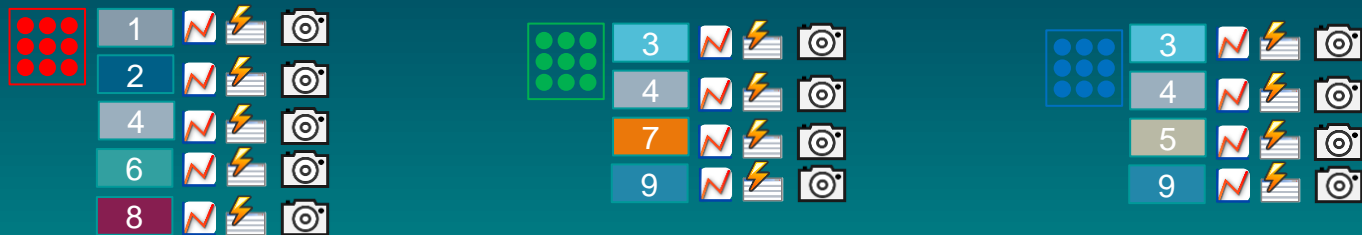
Batch concept in PM-QUALITY

Data recording

- If different stations are passed through during production, PM-QUALITY refers to a product batch consisting of several individual batches



On each station data (trends, alarms, snapshots 📈⚡📷) are recorded



System selection and components



PM-QUALITY Server

WinCC Unified PC



PM-QUALITY Server

WinCC V7 / Prof. PC




PM-QUALITY Server

Standalone Server PC

PM-QUALITY Server


Central batch data recording of trends, alarms, phases, snapshots

System selection and components




PM-QUALITY Server

WinCC Unified PC



PM-QUALITY Server

WinCC V7 / Prof. PC



PM-QUALITY Server

Standalone Server PC

PM-QUALITY Clients

Clients available for multiple SIMATIC HMI's

PM-QUALITY Client




WinCC Unified PC

PM-QUALITY Client



Unified Comfort Panel

PM-QUALITY Client



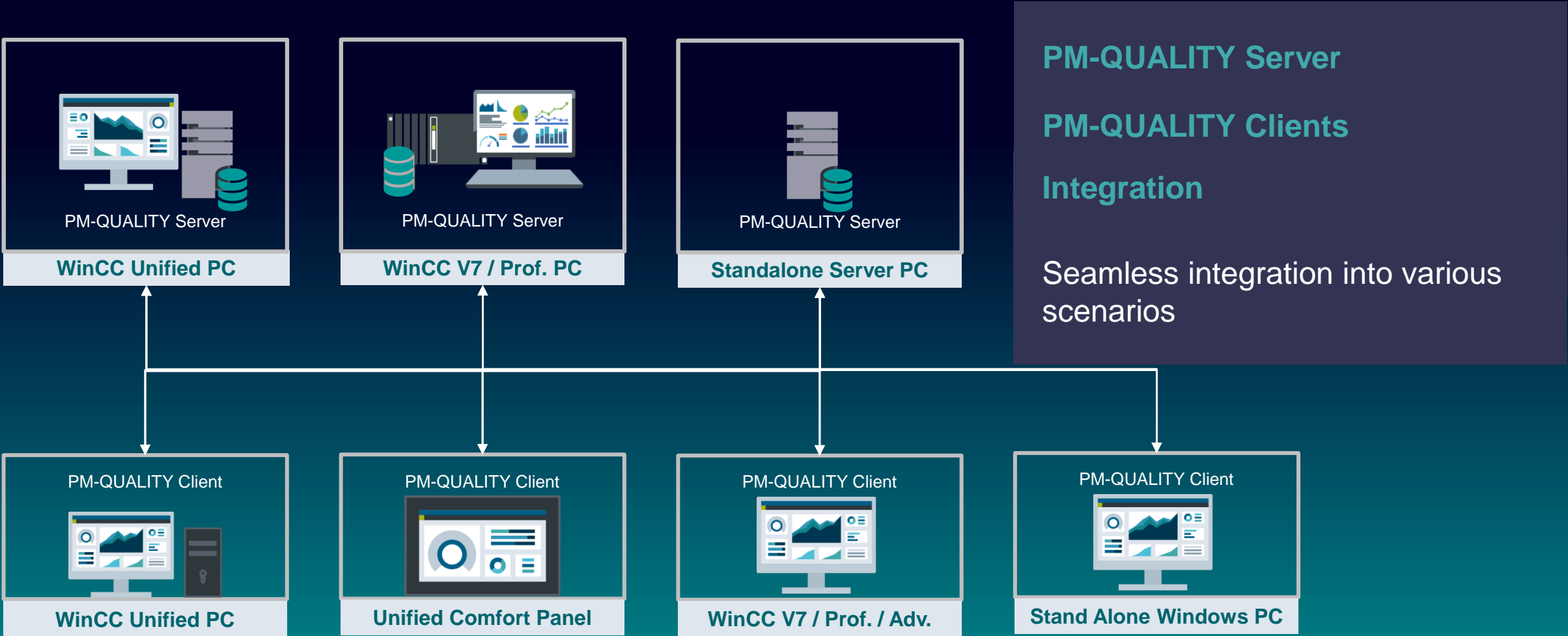
WinCC V7 / Prof. / Adv.

PM-QUALITY Client



Stand Alone Windows PC

System selection and components



System selection and components

Modular combinable



PM-QUALITY + PM-CONTROL
Server

WinCC Unified PC



PM-QUALITY + PM-CONTROL
Server

WinCC V7 / Prof. PC



PM-QUALITY + PM-CONTROL
Server

Standalone Server PC

**PM-QUALITY + PM-CONTROL
Server**

Central batch data recording +
Central recipe management



WinCC Unified PC



Unified Comfort Panel



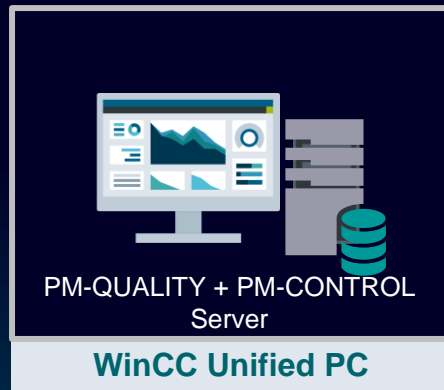
WinCC V7 / Prof. / Adv.



Standalone Windows PC

System selection and components

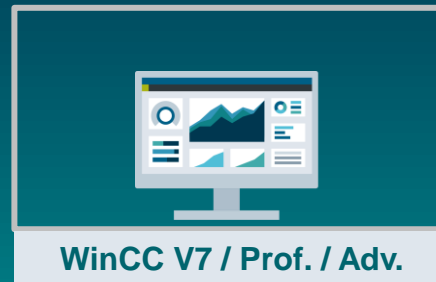
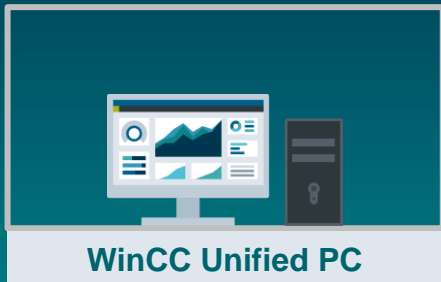
Modular combinable



PM-QUALITY + PM-CONTROL Server

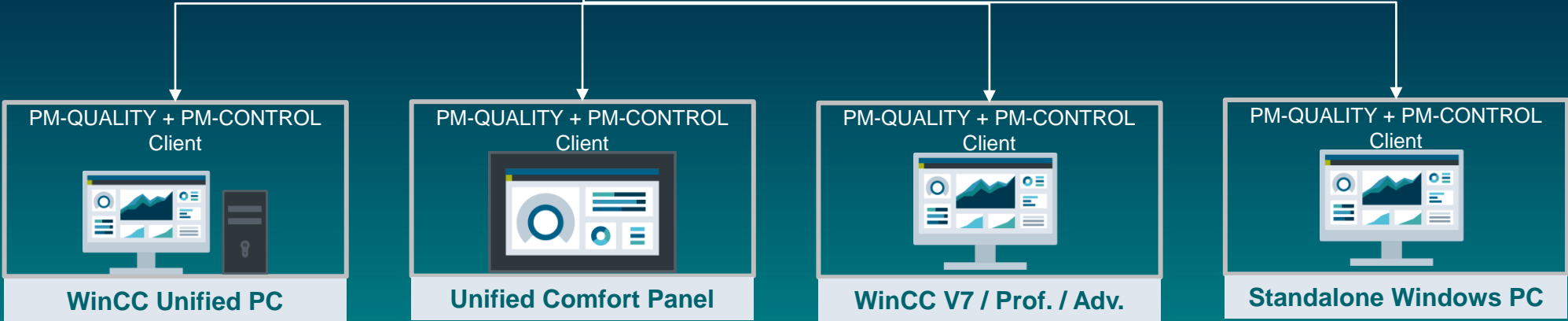
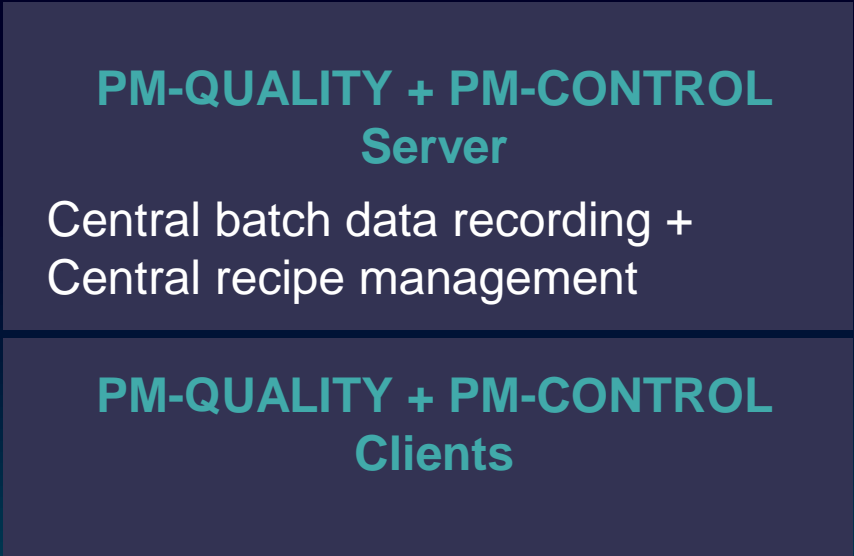
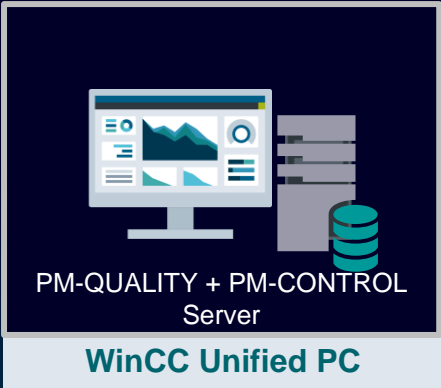
Central batch data recording +
Central recipe management

PM-QUALITY + PM-CONTROL Clients



System selection and components

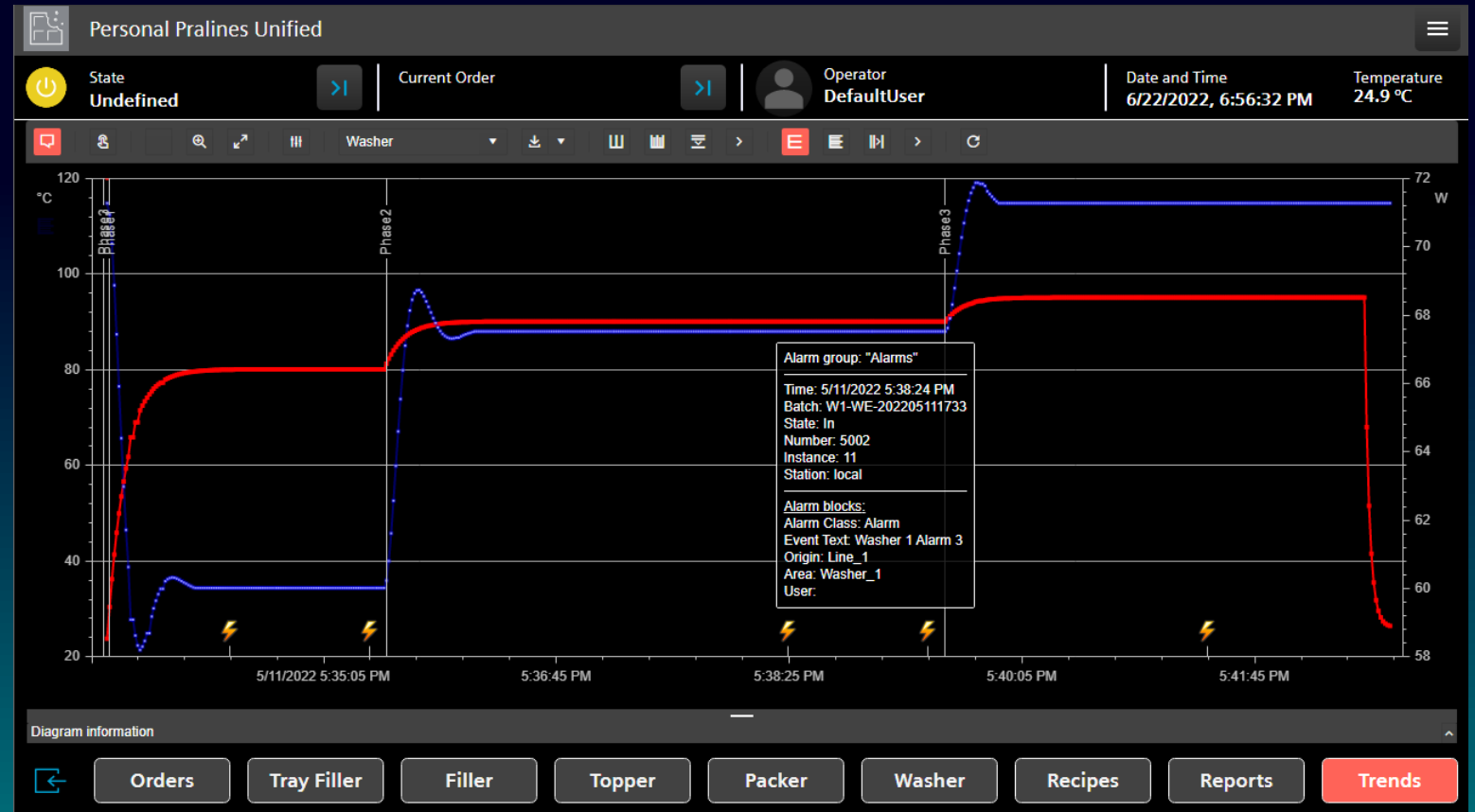
Modular combinable



System selection and components

PM-QUALITY batch trends

- Alarm display inside the trend
- As tooltip and/or table



System selection and components

PM-QUALITY batch trends

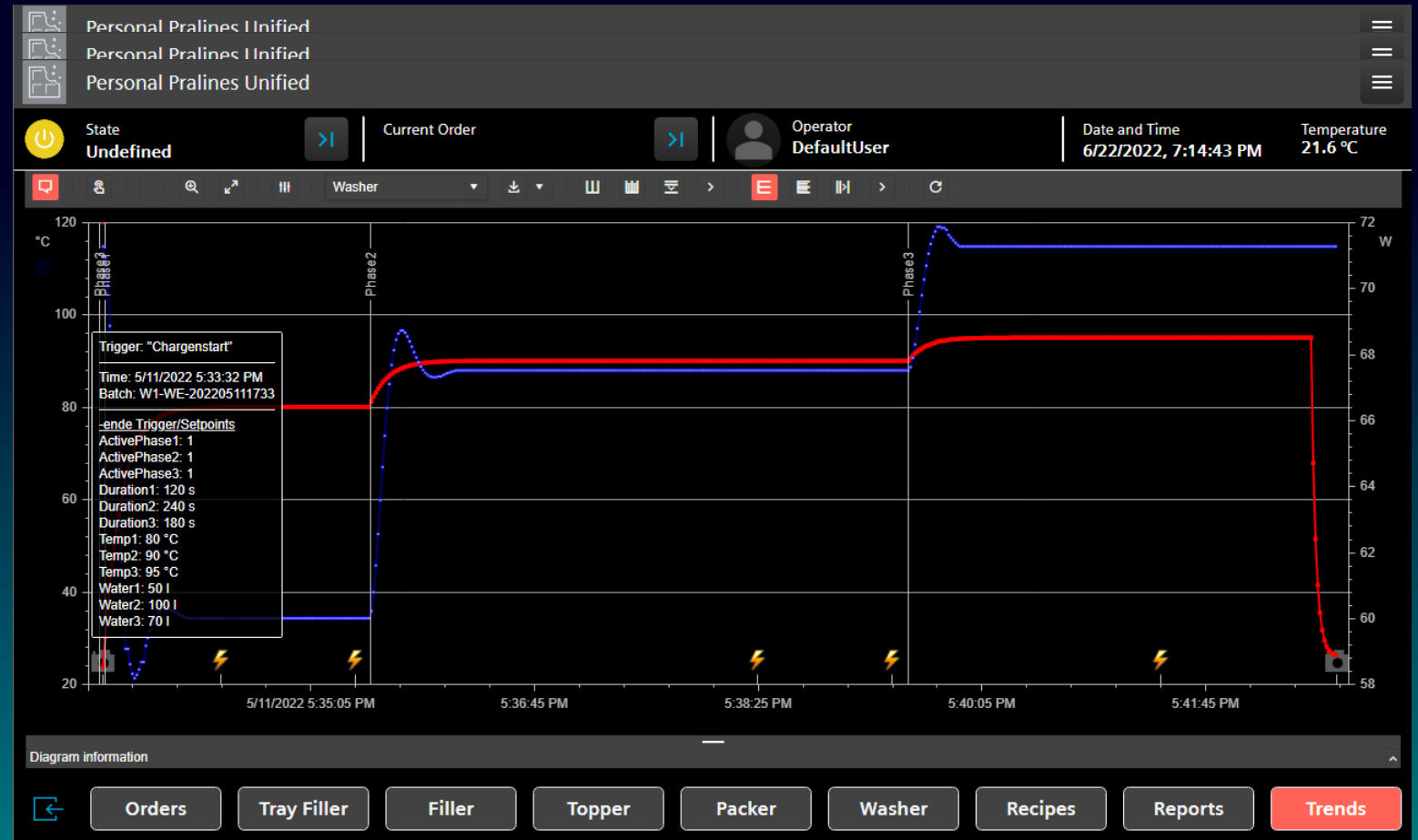
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System selection and components

PM-QUALITY batch trends

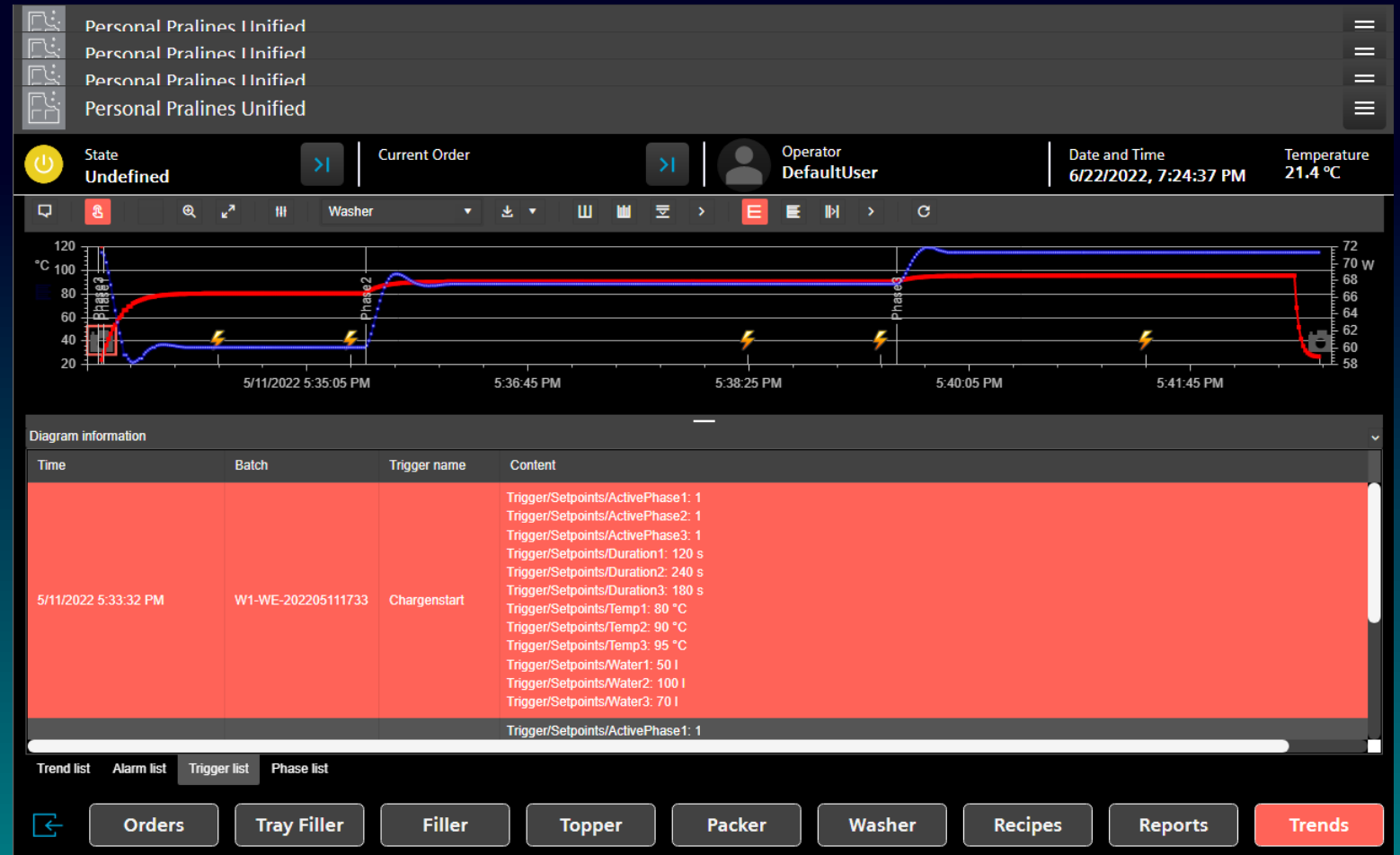
- Alarm display inside the trend
 - As tooltip and/or table
- Display of trigger events
 - As tooltip and/or table



System selection and components

PM-QUALITY batch trends

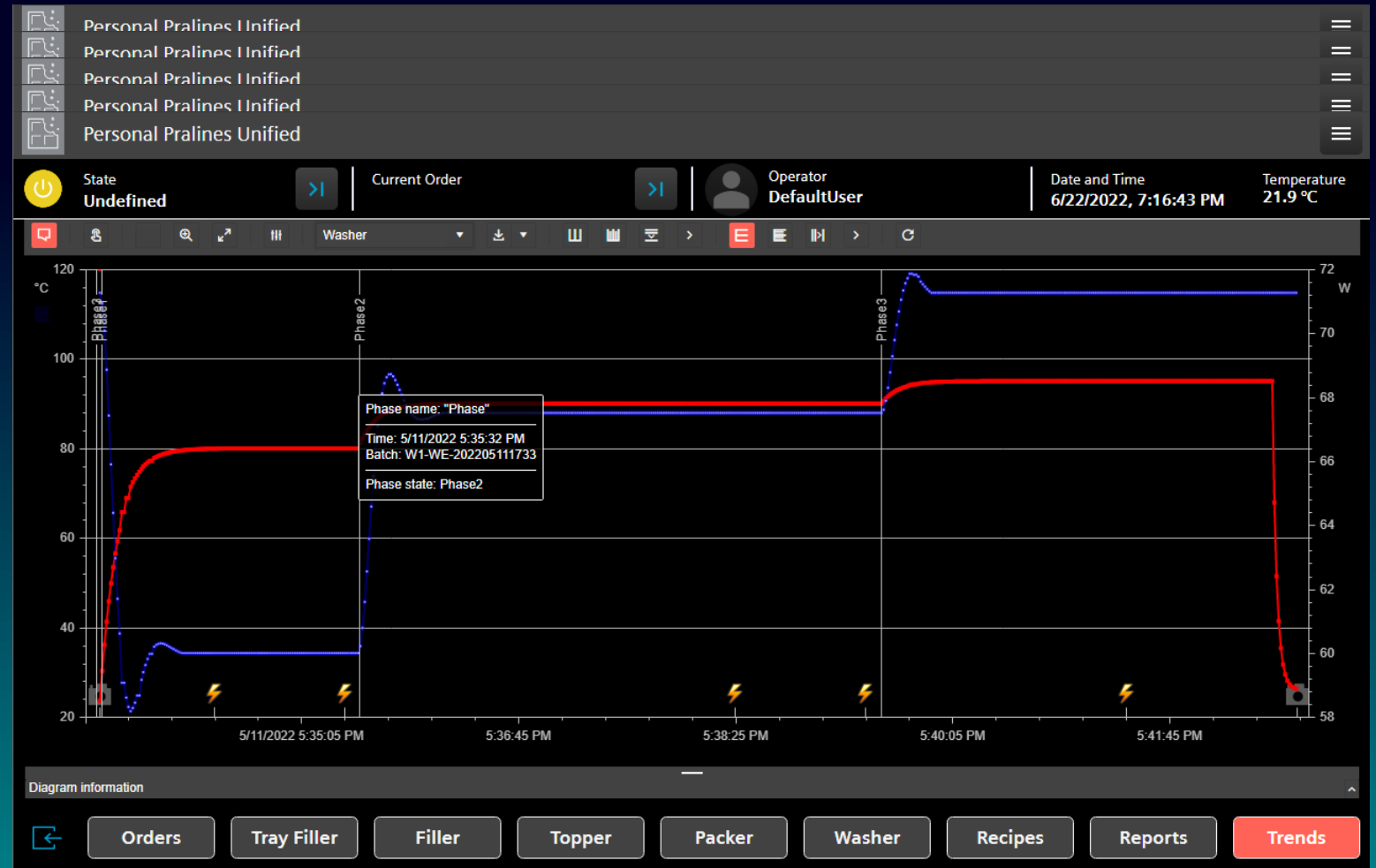
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System selection and components

PM-QUALITY batch trends

- Alarm display inside the trend
 - As tooltip and/or table
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 - As tooltip and/or table
- Display of process states/phases
 - As tooltip and/or table



System selection and components

PM-QUALITY batch trends

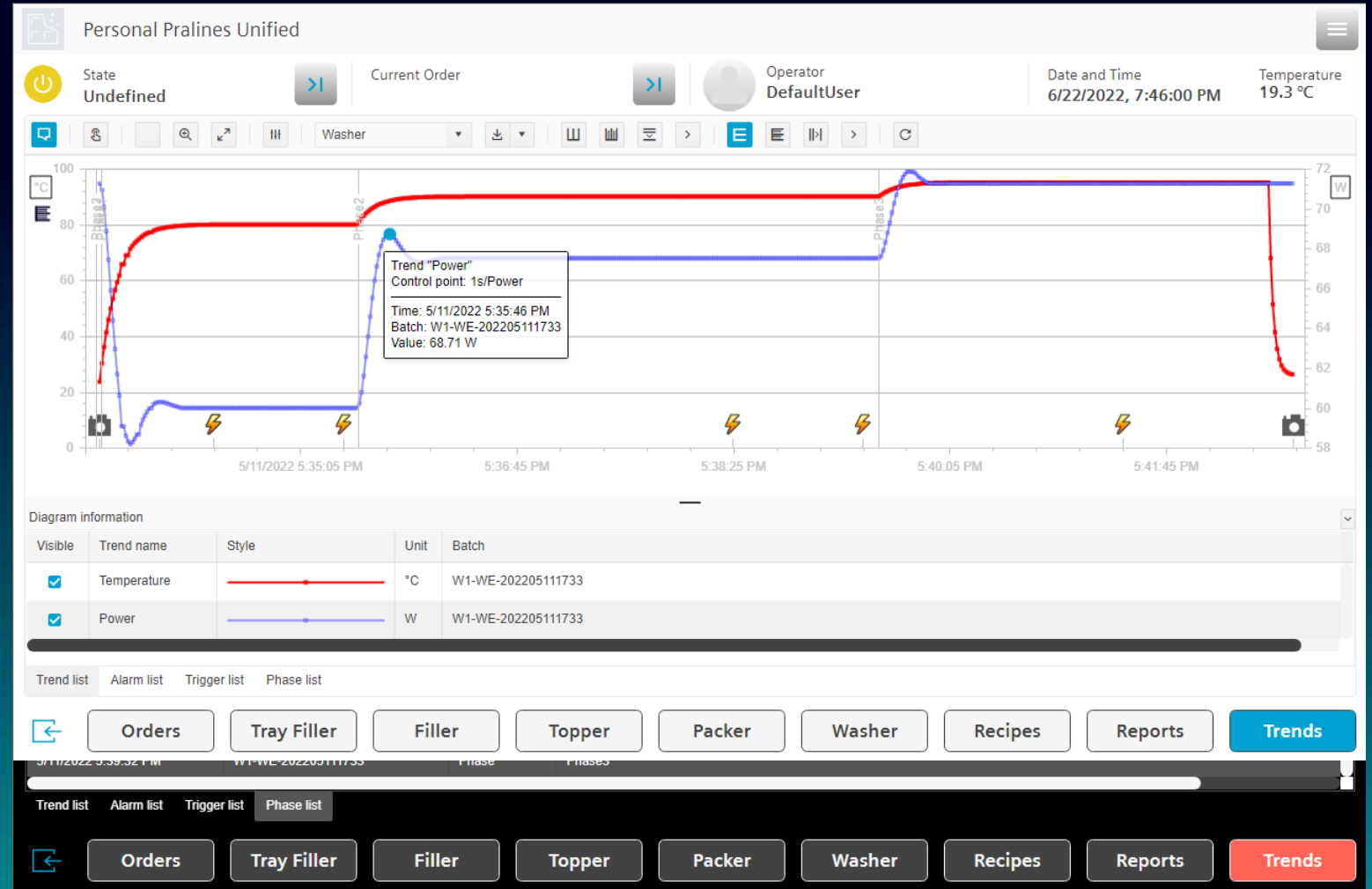
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PM-QUALITY batch trends

- Alarm display inside the trend
 - As tooltip and/or table
- Display of trigger events
 - As tooltip and/or table
- Display of process states/phases
 - As tooltip and/or table
- Extensive design options for seamless integration into the HMI design



System selection and components

PM-QUALITY batch trends

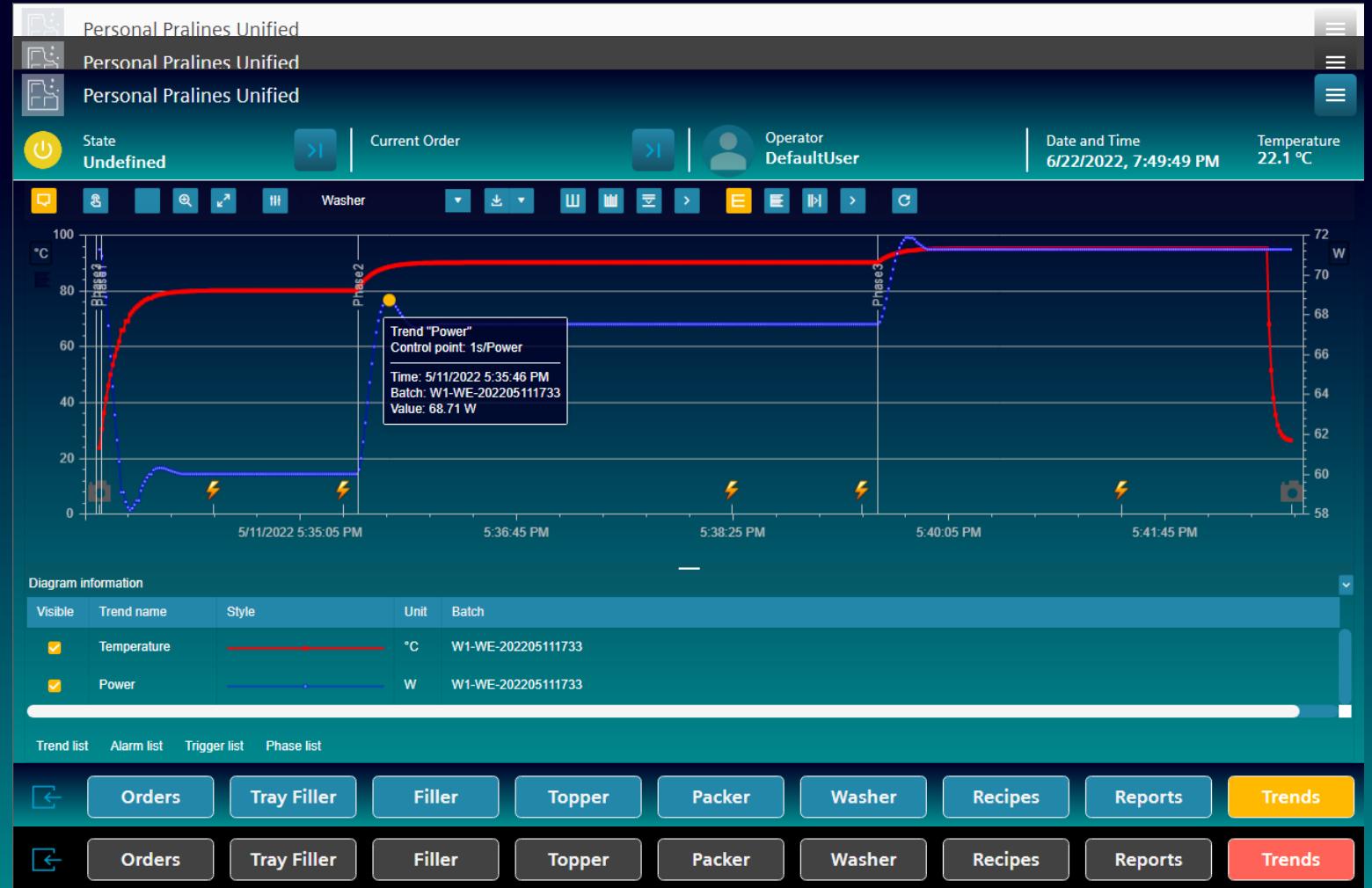
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System selection and components

PM-QUALITY batch trends

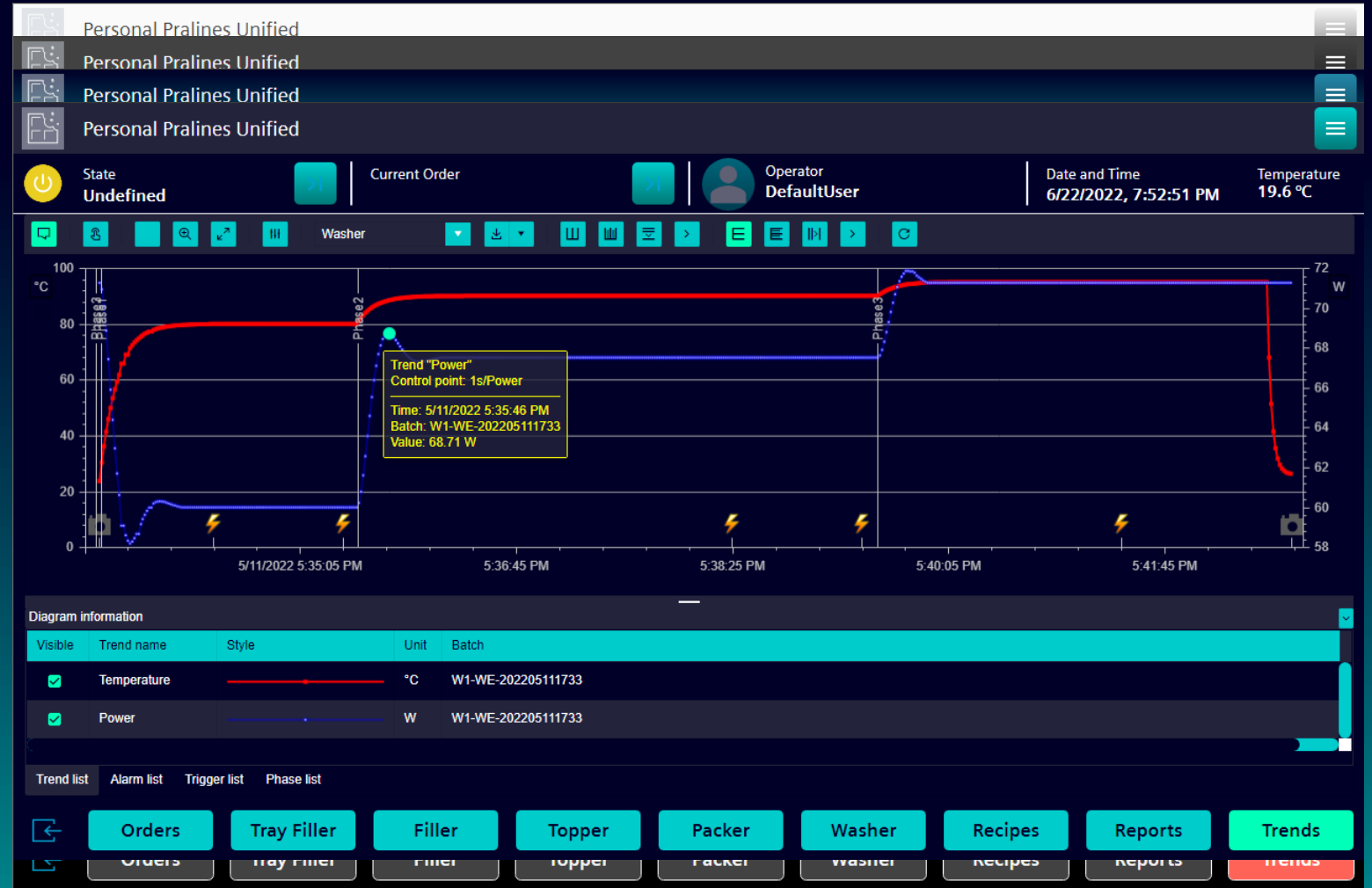
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System selection and components

PM-QUALITY batch trends

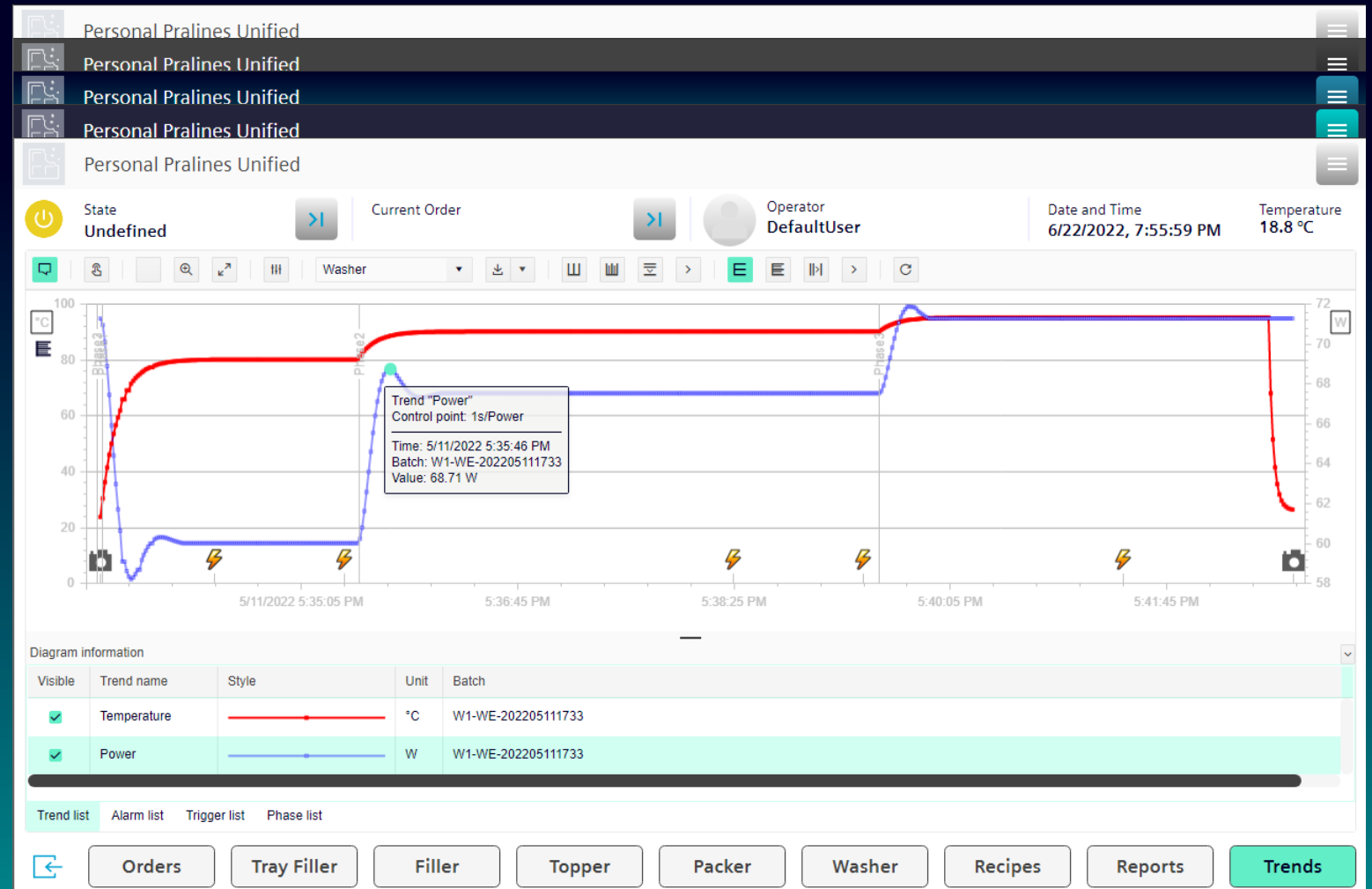
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- Display of process states/phases
 - As tooltip and/or table
- Extensive design options for seamless integration into the HMI design



System selection and components

PM-QUALITY batch trends

- Alarm display inside the trend
 - As tooltip and/or table
- Display of trigger events
 - As tooltip and/or table
- Display of process states/phases
 - As tooltip and/or table
- Extensive design options for seamless integration into the HMI design



System selection and components

PM-QUALITY batch table

- Various Search- and filter functions
e.g., by
 - Batch name
 - Production time
 - Batch header info fields
- Persistent custom filtersets

Personal Pralines Unified

State: Undefined | Current Order: | Operator: Operator | Date and Time: 6/22/2022, 8:18:32 PM | Temperature: 17.9 °C

18 | Last n Months: 2 | Start Time: 4/22/2022 8:11 PM | End Time: 6/22/2022 8:11 PM

State	Batch Name	Production Unit	Start Time	End Time	Recipe	Version
☐	W1-WE-202205081808	Washer1	5/8/2022 6:08 PM	5/8/2022 6:18 PM	WE	V2
☐	W1-WE-202205081818	Washer1	5/8/2022 6:18 PM	5/8/2022 6:27 PM	WE	V2
☐	W1-WE-202205081827	Washer1	5/8/2022 6:27 PM	5/8/2022 6:36 PM	WE	V2
☐	W1-WE-202205081837	Washer1	5/8/2022 6:37 PM	5/8/2022 6:46 PM	WE	V2
☐	W1-WE-202205081846	Washer1	5/8/2022 6:46 PM	5/8/2022 6:55 PM	WE	V2
☐	W1-WE-202205081856	Washer1	5/8/2022 6:56 PM	5/8/2022 6:56 PM	WE	V2

Orders | Tray Filler | Filler | Topper | Packer | Washer | Recipes | Reports | Trends

System selection and components

PM-QUALITY batch table

- Various Search- and filter functions
e.g., by
 - Batch name
 - Production time
 - Batch header info fields
- Persistent custom filtersets
- Call up a report for the selected batch from within the HMI

Personal Pralines Unified

Personal Pralines Unified

State Undefined

Current Order

Operator Operator

Date and Time 6/22/2022, 8:27:20 PM

Temperature 16.6 °C

Washer Report

Last n Months 2

Start Time: 4/22/2022 8:23 PM

End Time: 6/22/2022 8:23 PM

State	Batch Name	Production Unit	Start Time	End Time	Recipe	Version
W1-WE-202205111733	Washer1	5/11/2022 5:33 PM	5/11/2022 5:42 PM	WE	V2	
W1-WE-202205111724	Washer1	5/11/2022 5:24 PM	5/11/2022 5:33 PM	WE	V2	
PO-000043	Line1	5/11/2022 5:22 PM	5/11/2022 5:22 PM			
W1-WE-202205111652	Washer1	5/11/2022 4:52 PM	5/11/2022 4:59 PM	WE	V2	
PO-000042	Line1	5/11/2022 4:51 PM	5/11/2022 4:52 PM			
W1-WE-202205081903	Washer1	5/8/2022 7:03 PM	5/8/2022 7:04 PM	WE	V2	
W1-WE-202205081856	Washer1	5/8/2022 6:56 PM	5/8/2022 6:56 PM	WE	V2	
W1-WE-202205081846	Washer1	5/8/2022 6:46 PM	5/8/2022 6:55 PM	WE	V2	
W1-WE-202205081837	Washer1	5/8/2022 6:37 PM	5/8/2022 6:46 PM	WE	V2	
W1-WE-202205081827	Washer1	5/8/2022 6:27 PM	5/8/2022 6:36 PM	WE	V2	
W1-WE-202205081818	Washer1	5/8/2022 6:18 PM	5/8/2022 6:27 PM	WE	V2	
W1-WE-202205081808	Washer1	5/8/2022 6:08 PM	5/8/2022 6:18 PM	WE	V2	
W1-WE-202205081759	Washer1	5/8/2022 5:59 PM	5/8/2022 6:08 PM	WE	V2	

Orders Tray Filler Filler Topper Packer Washer Recipes Reports Trends

System selection and components

PM-QUALITY batch table

- Various Search- and filter functions
e.g., by
 - Batch name
 - Production time
 - Batch header info fields
- Persistent custom filtersets
- Call up a report for the selected batch from within the HMI

The screenshot displays the Siemens HMI interface for a production system. At the top, there are three menu items labeled 'Personal Pralines Unified'. Below this, a status bar shows 'State Undefined', 'Current Order', 'Operator Operator', 'Date and Time 6/22/2022, 8:32:11 PM', and 'Temperature 16.9 °C'. The main content area is titled 'Report for Batch 'W1-WE-202205111733'' and includes a sub-header 'Personal Pralines Unified' with an image of a box of pralines. The report is divided into three sections: 'Washer report', 'Setpoints', and 'Trays'. The 'Washer report' section contains a table with columns for Unit, Batch name, Recipe, and Start - End. The 'Setpoints' section contains a table with columns for Active, Duration [s], Temperature [°C], and Water [l]. The 'Trays' section contains a table with columns for Time, Tray1, Tray2, Tray3, Tray4, Tray5, Tray6, Tray7, Tray8, Tray9, and Tray10. Below these sections, there is a 'Phase' section with a table showing Time and Phases. At the bottom of the interface, there is a navigation bar with buttons for Orders, Tray Filler, Filler, Topper, Packer, Washer, Recipes, Reports, and Trends. The 'Reports' button is highlighted in red.

Unit	Batch name	Recipe	Start - End
Washer1	W1-WE-202205111733	WE	5/11/2022 5:33:30 PM 5/11/2022 5:42:43 PM

Active	Duration [s]	Temperature [°C]	Water [l]
Phase 1	120	80.00	50.00
Phase 2	240	90.00	100.00
Phase 3	180	95.00	70.00

Time	Tray1	Tray2	Tray3	Tray4	Tray5	Tray6	Tray7	Tray8	Tray9	Tray10
5/11/2022 5:33:32 PM	TR-000008	TR-000009	TR-000010	TR-000193	TR-000194	TR-000195	TR-000196	TR-000197	TR-000198	TR-000199

Time	Phases
5/11/2022 5:33:30 PM	Phase3
5/11/2022 5:33:33 PM	Phase1
5/11/2022 5:35:32 PM	Phase2

System selection and components

PM-QUALITY batch table

- Various Search- and filter functions
e.g., by
 - Batch name
 - Production time
 - Batch header info fields
- Persistent custom filtersets
- Call up a report for the selected batch from within the HMI
- Multiple report layouts per production unit

Personal Pralines Unified

Personal Pralines Unified

Personal Pralines Unified

Personal Pralines Unified

State: Undefined

Current Order

Operator: DefaultUser

Date and Time: 6/23/2022, 5:42:43 PM

Temperature: 30.4 °C

Line

Tray Tracking Report

Fillings Report

Box Tracking Report

State	Production Unit	Start Time	End Time	Recipe	Version
PO-000046	Line1	6/19/2022 7:37 PM	6/19/2022 7:37 PM		
PO-000045	Line1	6/19/2022 6:51 PM	6/19/2022 6:51 PM		
PO-000044	Line1	6/19/2022 6:09 PM	6/19/2022 6:09 PM		
PO-000043	Line1	5/11/2022 5:22 PM	5/11/2022 5:22 PM		
PO-000042	Line1	5/11/2022 4:51 PM	5/11/2022 4:52 PM		
PO-000041	Line1	5/6/2022 1:44 PM	5/6/2022 1:44 PM		
PO-000040	Line1	5/5/2022 5:34 PM	5/5/2022 5:34 PM		
PO-000039	Line1	5/5/2022 5:28 PM	5/5/2022 5:28 PM		
PO-000038	Line1	5/5/2022 3:55 PM	5/5/2022 3:55 PM		
PO-000037	Line1	5/5/2022 3:41 PM	5/5/2022 3:41 PM		
PO-000036	Line1	5/2/2022 5:39 PM	5/2/2022 5:39 PM		
PO-000035	Line1	5/2/2022 2:51 PM	5/2/2022 2:51 PM		

Orders

Tray Filler

Filler

Topper

Packer

Washer

Recipes

Reports

Trends

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